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D3391-025
Job Sheet 191383



Part No: D3391-025

Job Qty: 1 ea

Part Name: Aft Tube Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/28/19

Job Tracking No:

Due Date: 4/4/19

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV J SHEETS 9,10,11 IPP Rev B 06-02-07 ECN773 dwg rev. D EC IPP Rev:C 06-03-28 Update
Manuf. Instructions JLM IPP rev D 07.03.20 revF dwg EC IPP rev E 07.11.07 rev G dwg ecn 1053p EC verified
by: DD IPP Rev:F 07-11-13 ECN 1056 DD verified by: EC IPP Rev:G 08-09-10 revH as per dwg DD verified
by:EC IPP Rev:H 11.11.14 AS PER REV.I DD verified by:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	4/4/19	4/4/19	0.00	0.00	Start Up Crosstubes		2019-02-28 DAS
100	Mori Seiki	1 pcs	4/4/19	4/4/19	2.49	4.17	Mori Seiki TL-40		2019-03-04 66
110	QC	1 pcs	4/4/19	4/4/19	0.00	0.00	QC2-1		2019-03-04 9-89
112	QC	1 pcs	4/4/19	4/4/19	0.00	0.00	QC5		MAR 04 2019 68
120	CNC Vertical Machining	1 pcs	4/4/19	4/4/19	0.00	2.63	HAAS1-3		Kt 19-03-15 89
130	QC	1 pcs	4/4/19	4/4/19	0.00	0.00	QC2 Machining-2		Kt 19-03-15
140	QC	1 pcs	4/4/19	4/4/19	0.00	0.00	QC8 Machining-2		2019/03/17
150	Skidtubes	1 pcs	4/4/19	4/4/19	0.00	1.03	Skidtubes-4		M6A
160	CNC Bend Skidtubes	1 pcs	4/4/19	4/4/19	0.00	1.33	CNC Bend Skidtube		M6A
170	QC	1 pcs	4/4/19	4/4/19	0.00	0.00	QC5		BE
180	Skidtubes	1 pcs	4/4/19	4/4/19	0.00	1.03	Skidtubes-4		M6A
190	QC	1 pcs	4/4/19	4/4/19	0.00	0.00	QC5		19-04-15
200	HandFinish	1 pcs	4/4/19	4/4/19	0.00	0.58	HandFinish1		D.R 19/04/15
210	QC	1 pcs	4/4/19	4/4/19	0.00	0.00	QC7-2		M6A
220	Skidtubes	1 pcs	4/4/19	4/4/19	0.00	1.41	Skidtubes-4		M6A DAS
230	QC	1 pcs	4/4/19	4/4/19	0.00	0.00	QC5		MAY 16 2019 68
235	HandFinish	1 pcs	4/4/19	4/4/19	0.00	0.58	HandFinish2		MAY 22 2019 9-89
240	SprayPaint	1 pcs	4/4/19	4/4/19	0.00	0.25	Spray Paint		19-5-24
242	Outsource	1 pcs	4/4/19	4/4/19			ATE003-VC		NR
250	QC	1 pcs	4/4/19	4/4/19	0.00	0.00	QC14		M 19-5-28
260	HandFinish	1 pcs	4/4/19	4/4/19	0.00	0.58	HandFinish4		M 19-5-28 DAS
270	QC	1 pcs	4/4/19	4/4/19	0.00	0.00	QC5		JUN 03 2019 68
280	Packaging	1 pcs	4/4/19	4/4/19	0.00	0.00	Packaging3-1		DAS 19-6-12 9-89
290	QC21-SA	1 Ea	4/4/19	4/4/19	0.00	0.00	QC21		21 JUN 17 2019

Part Op 100 - Turn as per Folio FA599 Rev: J & Dwg D3391 Rev: J ***ensure steady rest is turning true*** *****REMOVE
 Descriptions: STEADY REST AND MACHINIG MARKS****

120 - 1-Machine as per Folio FA 599 Rev: J & Dwg D3391 Rev: J

140 - ***INSPECT INSIDE BORE***

150 - 1-Drill (PILOT HOLE) aft cap holes per Dwg D3391 using DT8803

160 - Form as per Dwg D3391 Using Bend Prog 3391025

180 - 1-Open Aft cap pilot hole to .208" as per Dwg D3391 2-Drill float bag holes using DT8809 as per Dwg D3391(Holes marked "A" Only. 3-Drill wearplate holes as per Dwg D3391 using DT8878(Mid Tube) & DT8217 Wearplate Jig . *****Do Not Open To Finished Size***** 4-Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2 previously drilled aft wearplate holes. 5-Open wearplate holes to 0.297" and c'bore as per dwg D3391 6-Open up all float bag holes to 0.328" and c'sink as per Dwg D3391. 8- Scribe batch # on fwd end

220 - 1- Instal spacers as per dwg D3391 A/R Magnabond 6398 Batch: S/40436 exp. date : 19-10-31 cure time 12hrs as per QSI0015 2- Grind crossbolts flush 3- Back drill using #9 drill 4- Touchup Magnabond 5- Deburr

235 - AND REALODINE AS PER PAR09-043

240 - PRIME AS PER DWG AND QSI005 4.2.1.3.3 Primer S103577 Paint S17047

260 - 1-Install inserts as per Dwg D3391 2-Install Aft Cap as per Dwg D3391 A/ R Sikaflex-241/-291 9174342 Sikaflex expiry date: 14-12-9 3- INSTALL WEARPLATES AS PER DWG

290 - 5- Detail DD, open (5) forward wearplate holes 0.375", then use DT10247 and drill holes for nutplates and c'sink. 6- Open wearplate holes to 0.297" and c'bore as per dwg D3391. ***SIX FARTHEST AFT HOLES ONLY*** 7-Open up all float bag holes to 0.328" and c'sink as per Dwg D3391. 8-Deburr 9- Scribe batch # on fwd end

Job BOM					010027
Part / Item	Component Name	Quantity	Operation	Container	
D6014-090	Aluminum Extrusion	1 pcs (1 ea)	90-Start up Operation		5139427
D3670-4-200	Bushing	4 pcs (4 ea)	220-Skidtubes		S 123086
ALS4-1032-130	Rivnut	8 Ea (8 ea)	260-HandFinish		5057257
ALS4-1032-225	Rivnut	4 Ea (4 ea)	260-HandFinish		5167512
AN3C4A	Bolt	6 Ea (6 ea)	260-HandFinish		5143678
AN3C5A	Bolt	4 Ea (4 ea)	260-HandFinish		5174232
D2646	Aft Cap	1 pcs (1 ea)	260-HandFinish		5160607
D3672-1	Washer, Phenolic	2 pcs (2 ea)	260-HandFinish		5164009
D4095-047	Wearpad Aft	1 pcs (1 ea)	260-HandFinish		5070710
D4095-049	Wearpad Aft	1 pcs (1 ea)	260-HandFinish		5116502
MS20601-AD4W3	Rivet	12 Ea (12 ea)	260-HandFinish		5160312
MS20601-AD4W7	Rivet	8 Ea (8 ea)	260-HandFinish		5137148
MS21075L5	Nut Plate	10 Ea (10 ea)	260-HandFinish		5093726
NAS1149C0332R	Washer	10 Ea (10 ea)	260-HandFinish		5158079

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6014-090	1	1	0
220-Skidtubes	D3670-4-200	4	98	0
260-HandFinish	ALS4-1032-130	8	9,354	0
	ALS4-1032-225	4	954	0
	AN3C4A	6	2,098	0
	AN3C5A	4	1,483	0
	D2646	1	17	0
	D3672-1	2	1,883	0
	D4095-047	1	32	0
	D4095-049	1	24	0
	MS20601-AD4W3	12	496	0
	MS20601-AD4W7	8	122	0
	MS21075L5	10	149	0
	NAS1149C0332R	10	3,718	0

Part Specifications				
Specifications could not be found.				



Container No: S157827



Part: D3391 – 025
Job No: 191383
Serial No/Batch: S157827
Revision:
Inspector:
Exp Date:
Instructions: Various STC's

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Date: 02/28/19

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DART AEROSPACE LTD	Work Order:	91383
Description: Float Skidtube (412)	Part Number:	D3391-3
Inspection Dwg: D3391 Rev: J		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Lathe Section						
14.000	+/-0.010	14.000	✓		Tape	
3.500	+/-0.010	3.495	✓		CNC-08	
Ø3.200	+/-0.010	3.200	✓		CNC-05	
Ø3.750	+/-0.010	3.750	✓		CNC-05	
30° x 0.060 chamfer	+/-0.010	.065	✓		CNC-08	
88.93	+/-0.030	88.935	✓		Tape	

Measured by:	66 M.D. DAS	Date:	2019-03-04
Audited by:	9-89 68	Date:	MAR 04 2019

HAAS Section						
1.526	+0.000/-0.030	1.505	✓		Kt-05	vern
7.500	+/-0.010	7.500	✓		"	"
27.750	+/-0.010	27.750	✓		Tape	
31.750	+/-0.010	31.750	✓		"	"
35.250	+/-0.010	35.250	✓		"	"
3.300	+/-0.010	3.300	✓		Kt-05	vern
0.200	+/-0.010	0.200	✓		"	"
3.520	+/-0.010	3.521	✓		SL-05	micrometer
0.687	+0.010/-0.000	0.689	✓		Kt-05	vern.
R0.062	+/-0.010	0.0625	✓			R-6
Ø0.484	+0.005/-0.001	0.484	✓		Kt-05	vern

Measured by:	1/11 9-89	Date:	19/03/15
Audited by:	9-89	Date:	19/03/17

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-015/-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	
C	07.04.20	Ø0.208 dimension removed	KJ/JLM	
D	07.09.06	0.400 dimension removed	KJ/JLM	
E	07.11.23	Dwg Rev. updated	KJ/EC/DD	
F	09.04.27	Dimensions updated per Rev H and NCR09-028	KJ/JLM	
G	09.11.16	Dimension 0.200 removed	KJ	
H	11.06.21	Dimension 44.995 removed	KJ	
I	12.05.15	Dwg Rev updated	KJ	
J	12.05.23	Dimension updated	KJ	
K	12.10.15	88.93 dimension removed	KJ	
L	12.11.28	88.93 dimension added	KJ	
M	16.06.23	Dimensions updated per Rev J	KJ	